

Work Order ID 130529

Friday, March 13, 2015 12:58:38 PM

130529

Page 1

Item ID: D5080-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Striker Plate
 Start Date: 3/13/2015 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 3/13/2015 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 15-03-13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5080	A								
100	FLOW WATER JET	0.00							
100	Waterjet	0.00				(12)			DC 15/03/17
FLOW CNC Waterjet	Memo 1-Cut as per Dwg Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary ***DO NOT OPEN HOLES, IT WILL BE DONE ON ASSEMBLY D5080-041***								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110	QC	0.00				(12)			DC 15/03/17
Quality Control	Memo								

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Item ID: D5080-3 Accept ***N900040100*** Setup Start ***NS1***
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

Identify as per dwg & Stock Location: ST-146 0.00***150***

Packaging

Memo

0.00

Packaging

DAS
06
9-89

APR 17 2015

160

QC21- Final Inspection - Work Order Release 0.00

160

QC

Memo

0.00

Quality Control

MLJ 15-04-20

MLJ 15-04-17

Picklist Print

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Work Order ID: 130529

130529

Parent Item: D5080-3

D5080-3

Parent Item Name: Striker Plate

Start Date: 3/13/2015

Required Date: 3/13/2015

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A 14.03.19 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S18GA

Purchased

No

sf

653.2910

1

M304S18GA

304/316 .050 Sheet

015/03/17

Location

Loc Qty

Loc Code

MAT

256

M131700

256

MAT020

397.291

124572

11.334

125552

18.0487

M126647

22.014

M128254

17.4387

M128435

27

M128864

31.5964

M129530

34.6667

M130345

11.1667

M130923

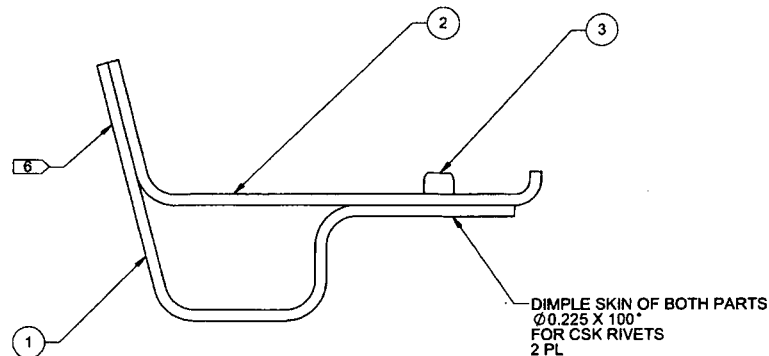
75.0424

M131384

148.9834

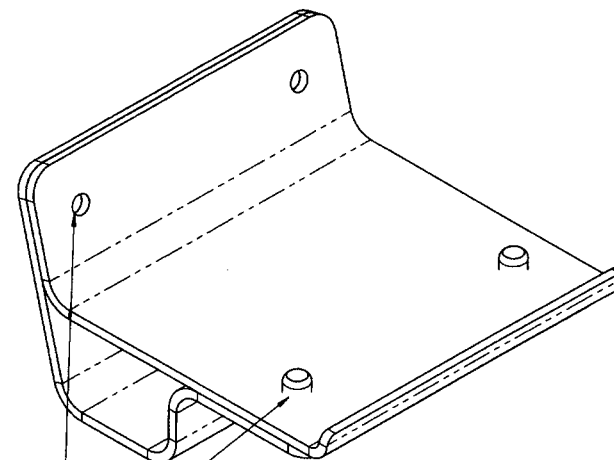
(1)

ITEM	QTY	P/N	DESCRIPTION
	X	D5080-041	STRIKER PLATE ASSY
1	1	D5080-1	ANGLE BRACKET
2	1	D5080-3	STRIKER PLATE
3	2	MS20426AD4-4	RIVET, SOLID, CSK



D5080-041 STRIKER PLATE ASSY

TRANSFER MARK HOLES FROM D5080-3
TO D5080-1 AND DRILL Ø0.128" 4 PL



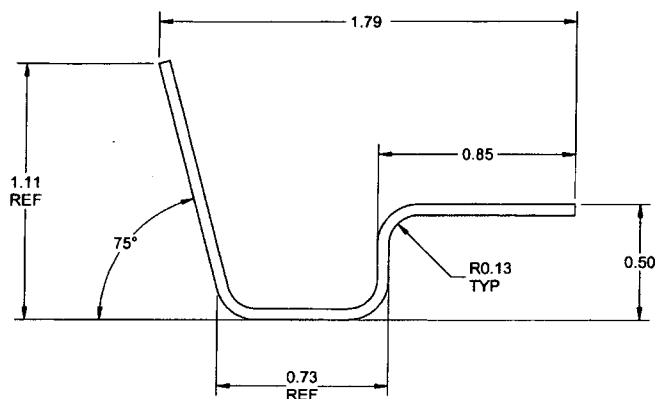
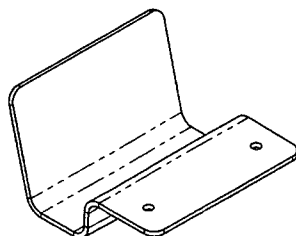
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.1
- 7) WEIGHT: 0.13 lbs

RELEASED
2014-04-23

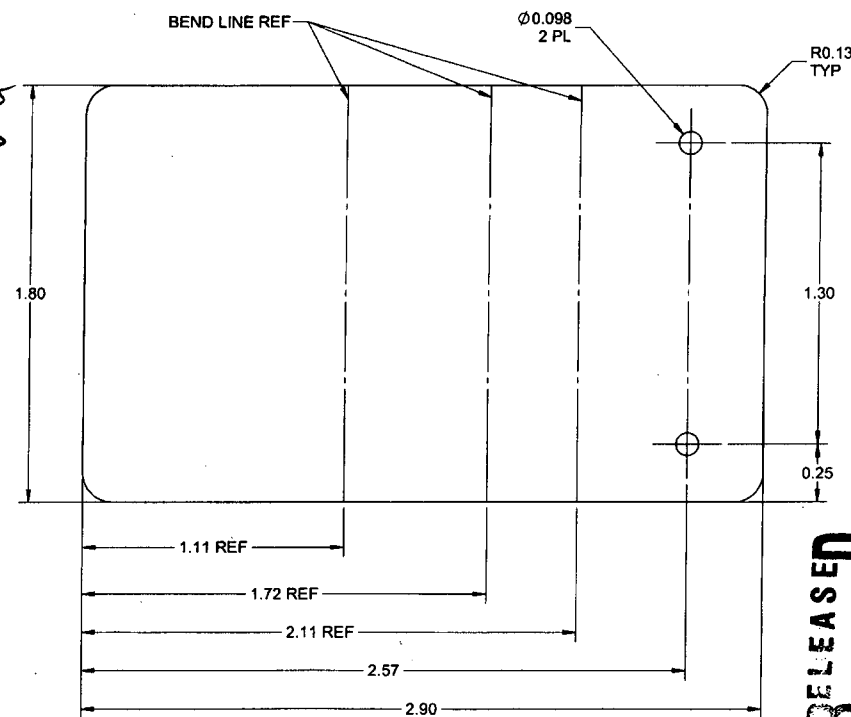
A		NEW ISSUE		ML	14.03.24
REV.	DESCRIPTION			BY	DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	ML				
CHECKED	AJS	DRAWING NO. D5080		SHEET 1 OF 3	
MFG. APPR.	DD	TITLE STRIKER PLATE ASSY		SCALE	
APPROVED	MP			NTS	
DE APPR.	DS	DATE 14.03.24		COPYRIGHT © 2014 BY DART AEROSPACE LTD	
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APPROVED



D5080-1 ANGLE BRACKET
MAKE FROM D5080-1F

130529 MLJ
15-03-13



D5080-1F FLAT PATTERN

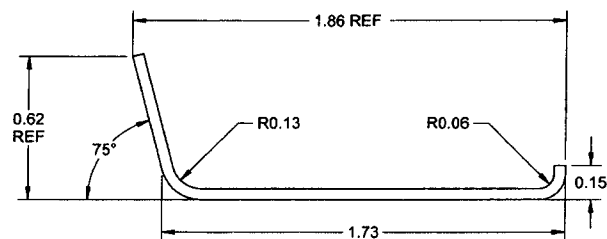
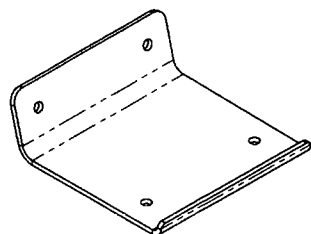
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.048" THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

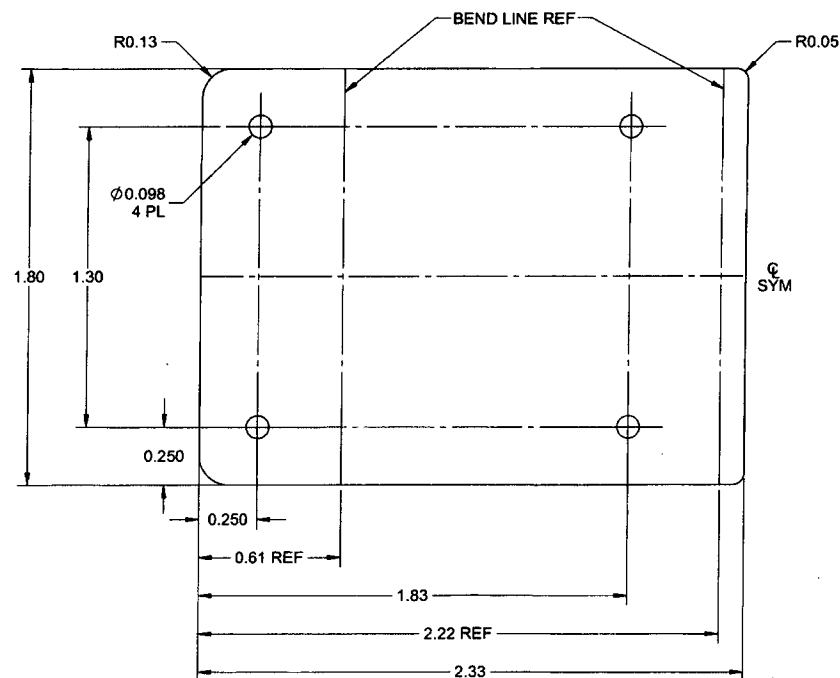
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DRAWN	ML		
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5080	SHEET 2 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	STRIKER PLATE ASSY	NTS
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RELEASED
2014-04-23



D5080-3 STRIKER PLATE
MAKE FROM D5080-3F



D5080-3F FLAT PATTERN

RELEASED
2014-04-23

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.048" THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC M304S18GA
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.06 lbs

APPROVED

DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5080	SHEET 3 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	D8	STRIKER PLATE ASSY	NTS
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